

Date: Wednesday, 13/08/2008 10:55:31 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 90 DEGREE BLADE SUPPORT ASSY		
Job Number	: 41214					
Estimate Number	: 13386					
P.O. Number	:			Part Number	: PB674300167	
This Issue	: 13/08/2008	S.O. No. :		Drawing Number	: B6743001 PAGE24	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 40243			Drawing Revision	: B1	
Written By	:			Material	:	
Checked & Approved By	: JUL 08 8.13			Due Date	: 15/09/2008	
Comment	: Est Rev:A 08-06-19 new issue DD verified by:ec			Qty:	6	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.6241 sf(s)/Unit Total : 3.7447 sf(s)

6061-T6 .090 Sheet

batch: 108595

FB 8-9-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-147

Dwg Rev: B1

Prog Rev: B1

1B 8-9-3

(B)

2-Deburr if necessary

FB 8-9-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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FB 8-9-3

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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S 08/08/08 + B

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Form as per dwg B67-43001

SB 08/09/15

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41214

Part Number: PB674300167

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/08/08 (8)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Side Plate 34/231 = 10 32409926 1/2 880092 17

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-21 (8)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (8)

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nutplate M10 9068

E 08/09/24

14.0 MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

RIVET M10 5978

E 08/09/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41214

Part Number: PB674300167

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

8/08/09/24 (8)

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/09/25 (8)

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 244

8/09/09

(8) 09

18.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 (8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

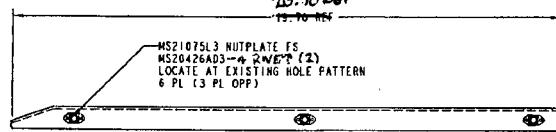
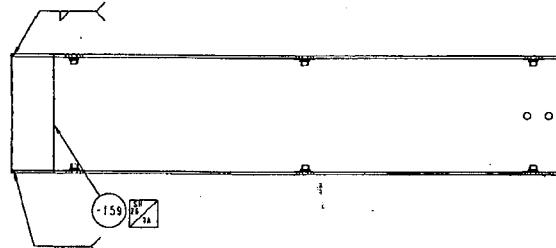
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

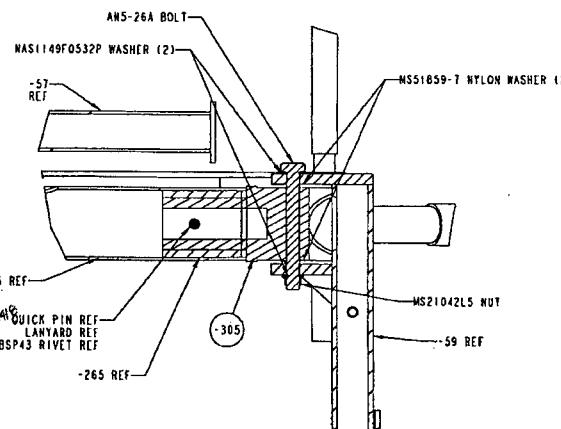
8 | 7 | 6 | 5 | 4 | 3 | 2 | 1

D

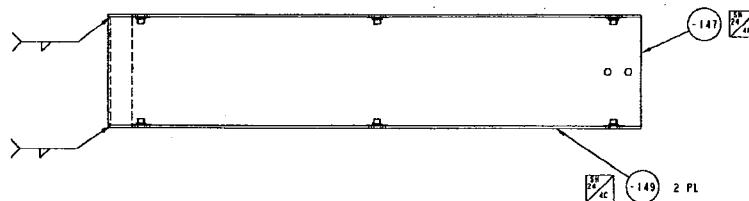


② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

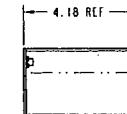
SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)



-149 2 PL



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500

WORK ORDER
NO. 4209
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

PREMIER AVIATION, INC.
800 Aviation Parkway, Grand Prairie, Texas 75050
DATE COST SHEET NO. B67-43001 B7
SCALE: 1:1 Sheet 1 of 45

ORIGINAL

8 | 7 | 6 | 5 | 4 | 3 | ? |

D

D

C

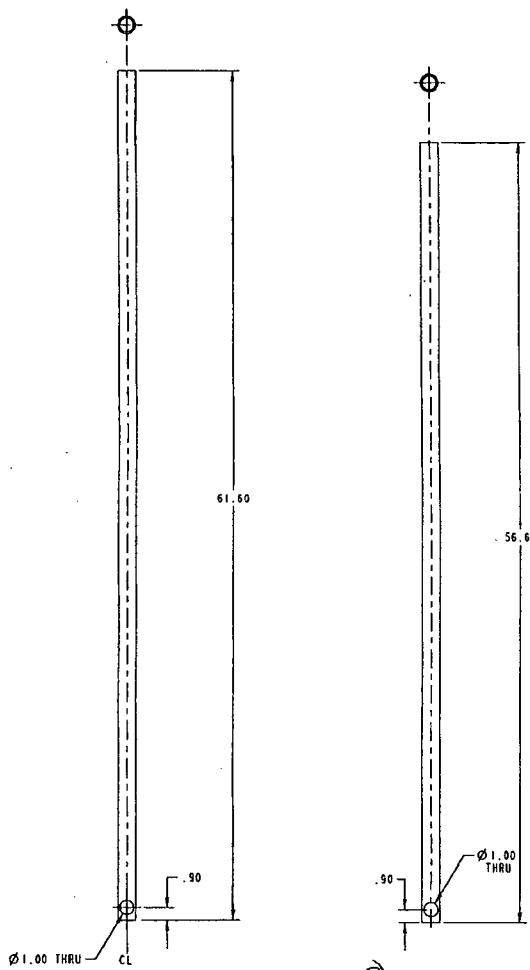
C

8

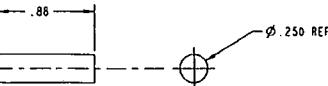
B

z

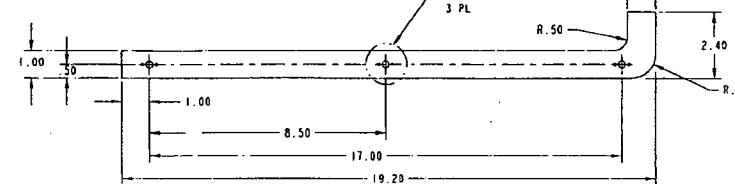
A



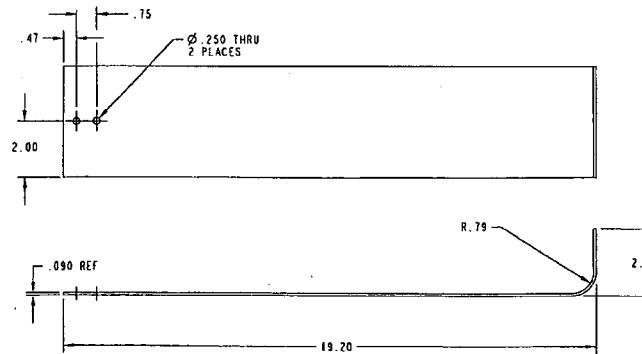
④ -259 INNER TUBE
MATERIAL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/
SCALE 0.250



155 PIN
MATL: .250 RND. 303 SS
AMSS640 COND A
SCALE 2.000



(4) -149 SIDE PLATE MATL: .090 THK. 6061-T6. QQ-A-250/I
SCALE 0.500



(2) - 147 SUPPORT PLATE ¹⁴
MATL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500

PREMIER AVIATION, INC.
2624 Aviation Parkway, Grand Prairie, Texas 75052

ORIGINAL

INVENTIVE
OD X .125 WALL
SCALE D.2
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 102

DART AEROSPACE LTD	Work Order:	4124
Description: 90° BLADE SUPPORT ASSY	Part Number:	PB 674 3001-147
Inspection Dwg:	Rev:	R1
		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 8-9-3	Date: 08/08/64	Date: 1/2

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	